



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

D119-646-043
Job Sheet 199136



Part No: D119-646-043

Job Qty: 1 pcs

Part Name: AW119 Replacement Skidtube with Wearpads, Float Compatible - Fits LH or RH



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 8/13/19

Job Tracking No:

Created By: Jennifer Renwick

Due Date: 10/29/19

Description:

Note: IIN-D119-646 REV.D, D3905-041 REV.F IPP RevA: New issue DD verified by:EC IPP revB 10.02.22 per PAR 09-043 EC verified by:DD IPP REV.C 12.11.05 (DEOD3905-B-1)(ecn 12-675) DD verf:JLM IPP REV:D 13.03.20 per chg003 ECN13-534 DD verf:JLM IPP REV:E 15.01.19 AS PER ECN-14-628 DD verf:JLM IPP REV:F 16.11.02 chg as per D3905 revD(DEO) DD verf:JLM IPP REV:G 17.05.23 as per dwg D3905 rev.e DD verf:JFS

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
110	Skidtubes - 1	1		10/29/19	0.00	3.68	Skidtubes - 1		
		pcs					Skidtubes - 2		
							Skidtubes - 3		
							Skidtubes - 4		
							Skidtubes - 5		
							Skidtubes - 6		
							Skidtubes - 7		
120	Handfinish - 1-1 Chemical-B4B	1		10/29/19	0.00	1.56	Handfinish - 1 - 1 - B4B		
		pcs					Handfinish - 1 - 2 - B4B		
							Handfinish - 1 - 3 - B4B		
							Handfinish - 1 - 4 - B4B		
							Handfinish - 1 - 5 - B4B		
							Handfinish - 1 - 6 - B4B		
							Handfinish - 1 - 7 - B4B		
							Handfinish - 1 - 8 - B4B		
							Handfinish - 1 - 9 - B4B		
							Handfinish - 1 - 10 - B4B		
							Handfinish - 1 - 11 - B4B		



Container No: S207599



Part: D119 - 646 - 043

Job No: 199136

Serial No/Batch: S207599

Revision: D,F

Inspector:

Exp Date:

Instructions: FAA STC SR02024SE 18/10/17, TC STC LoA P

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaero.com

Plex 8/13/19 1:02 PM Dart.Renwick.Jennife

					Handfinish - 1 - 12 - B4B	
					Handfinish - 1 - 13 - B4B	
					Handfinish - 1 - 14 - B4B	
					Handfinish - 1 - 15 - B4B	
					Handfinish - 1 - 16 - B4B	
					Handfinish - 1 - 17 - B4B	
					Handfinish - 1 - 18 - B4B	
					Handfinish - 1 - 19 - B4B	
					Handfinish - 1 - 20 - B4B	
					Handfinish - 1 - 21 - B4B	
					Handfinish - 1 - 22 - B4B	
130 QC 7	1 pcs	10/29/19	0.00	0.00	QC 7 - 10	
					QC 7 - 13	
					QC 7 - 14	
					QC 7 - 15	
					QC 7 - 17	
					QC 7 - 18	
					QC 7 - 19	
					QC 7 - 2	
					QC 7 - 28	
					QC 7 - 3	
					QC 7 - 30	
					QC 7 - 34	
					QC 7 - 36	
					QC 7 - 37	
					QC 7 - 41	
					QC 7 - 47	
					QC 7 - 48	
					QC 7 - 51	
					QC 7 - 58	
					QC 7 - 59	
					QC 7 - 60	M66
					QC 7 - 9	
					QC 7 - 68	
					QC 7 - 50	
					QC 7 - 67	
					QC 7 - 40	
					QC 7 - 24	
					QC 7 - 43	
					QC 7 - 61	
					QC 7 - 81	
140 QC 5	1 pcs	10/29/19	0.00	0.00	QC 5 - 10	
					QC 5 - 12	
					QC 5 - 17	
					QC 5 - 18	BF
					QC 5 - 19	
					QC 5 - 22	
					QC 5 - 24	
					QC 5 - 3	

						QC 5 - 43	
						QC 5 - 49	
						QC 5 - 51	
						QC 5 - 58	
						QC 5 - 68	
						QC 5 - 9	
						QC 5 - 50	
						QC 5 - 30	
						QC 5 - 40	
						QC 5 - 61	
						QC 5 - 81	
170 Skidtubes - 2 - B4B	1 pcs	10/29/19	0.00	3.68	Skidtubes - 1 - B4B		
					Skidtubes - 2 - B4B		
					Skidtubes - 3 - B4B	MKG	
					Skidtubes - 4 - B4B		
					Skidtubes - 5 - B4B		
					Skidtubes - 6 - B4B		
					Skidtubes - 7 - B4B		
180 QC 5	1 pcs	10/29/19	0.00	0.00	QC 5 - 10		
					QC 5 - 12		
					QC 5 - 17		
					QC 5 - 18	BE	
					QC 5 - 19		
					QC 5 - 22		
					QC 5 - 24		
					QC 5 - 3		
					QC 5 - 43		
					QC 5 - 49		
					QC 5 - 51		
					QC 5 - 58		
					QC 5 - 68		
					QC 5 - 9		
					QC 5 - 50		
					QC 5 - 30		
					QC 5 - 40		
					QC 5 - 61		
					QC 5 - 81		
190 Skidtubes - 3 - B4B	1 pcs	10/29/19	0.00	3.68	Skidtubes - 1 - B4B		
					Skidtubes - 2 - B4B		
					Skidtubes - 3 - B4B		
					Skidtubes - 4 - B4B		
					Skidtubes - 5 - B4B	BE	
					Skidtubes - 6 - B4B		
					Skidtubes - 7 - B4B		
200 QC 5	1 pcs	10/29/19	0.00	0.00	QC 5 - 10		
					QC 5 - 12		
					QC 5 - 17		
					QC 5 - 18		
					QC 5 - 19		
					QC 5 - 22		
					QC 5 - 24		
					QC 5 - 3		
					QC 5 - 43		
					QC 5 - 49		
					QC 5 - 51		
					QC 5 - 58		
					QC 5 - 68		
					QC 5 - 9		

					QC 5 - 50	
					QC 5 - 30	
					QC 5 - 40	AUG 30 2019
					QC 5 - 61	
					QC 5 - 81	
210 QC 10	1 pcs	10/29/19	0.00 0.00		QC 10 - 10	
					QC 10 - 18	
					QC 10 - 24	
					QC 10 - 43	
					QC 10 - 50	EL
					QC 10 - 58	
220 Handfinish - 2-1 Pressure-B4B	1 pcs	10/29/19	0.00 1.56		QC 10 - 9	
					Handfinish - 2 - 1 - B4B	
					Handfinish - 2 - 2 - B4B	
					Handfinish - 2 - 3 - B4B	
230 Spray Paint - 2 - B4B	1 pcs	10/29/19	0.00 0.42		Handfinish - 2 - 4 - B4B	Jul
					Spray Paint - 1 - B4B	
					Spray Paint - 2 - B4B	RD 19-8-31
					Spray Paint - 3 - B4B	
235 Outsource	1 pcs	10/29/19			Spray Paint - 4 - B4B	
					ATE003-VC	
240 QC 14	1 pcs	10/29/19	0.00 0.00		QC 14 - 15	Jul 19-9-4
					QC 14 - 2	
					QC 14 - 34	
					QC 14 - 41	
					QC 14 - 51	
					QC 14 - 58	
					QC 14 - 59	
					QC 14 - 9	
					QC 14 - 68	
					QC 14 - 40	
					QC 14 - 19	
					QC 14 - 43	
					QC 14 - 24	
					QC 14 - 61	
					QC 14 - 81	
250 Handfinish - 4-1-Assembly-B4B	1 pcs	10/29/19	0.00 1.56		Handfinish - 4 - 1 - B4B	Jul 19-9-4
					Handfinish - 4 - 10 - B4B	
					Handfinish - 4 - 11 - B4B	
					Handfinish - 4 - 12 - B4B	
					Handfinish - 4 - 13 - B4B	
					Handfinish - 4 - 14 - B4B	
					Handfinish - 4 - 15 - B4B	
					Handfinish - 4 - 2 - B4B	
					Handfinish - 4 - 3 - B4B	
					Handfinish - 4 - 4 - B4B	

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					Handfinish - 4 - 5 - B4B	
					Handfinish - 4 - 6 - B4B	
					Handfinish - 4 - 7 - B4B	
					Handfinish - 4 - 8 - B4B	
					Handfinish - 4 - 9 - B4B	
260 QC 5	1 pcs	10/29/19	0.00	0.00	QC 5 - 10	
					QC 5 - 12	
					QC 5 - 17	
					QC 5 - 18	
					QC 5 - 19	
					QC 5 - 22	
					QC 5 - 24	
					QC 5 - 3	
					QC 5 - 43	
					QC 5 - 49	
					QC 5 - 51	
					QC 5 - 58	
					QC 5 - 68	
					QC 5 - 9	
					QC 5 - 50	
					QC 5 - 30	
					QC 5 - 40	
					QC 5 - 61	
					QC 5 - 81	
270 Handfinish - 4-2-Assembly-B4B	1 pcs	10/29/19	0.00	1.56	Handfinish - 4 - 1 - B4B	
					Handfinish - 4 - 10 - B4B	
					Handfinish - 4 - 11 - B4B	
					Handfinish - 4 - 12 - B4B	
					Handfinish - 4 - 13 - B4B	
					Handfinish - 4 - 14 - B4B	
					Handfinish - 4 - 15 - B4B	
					Handfinish - 4 - 2 - B4B	
					Handfinish - 4 - 3 - B4B	
					Handfinish - 4 - 4 - B4B	
					Handfinish - 4 - 5 - B4B	
					Handfinish - 4 - 6 - B4B	
					Handfinish - 4 - 7 - B4B	
					Handfinish - 4 - 8 - B4B	
					Handfinish - 4 - 9 - B4B	
280 QC 5	1 pcs	10/29/19	0.00	0.00	QC 5 - 10	
					QC 5 - 12	
					QC 5 - 17	

DAS
81
9-89

SEP 04 2019

111 14-9-89

					QC 5 - 18	
					QC 5 - 19	
					QC 5 - 22	DAS
					QC 5 - 24	19
					QC 5 - 3	9-89
					QC 5 - 43	
					QC 5 - 49	
					QC 5 - 51	
					QC 5 - 58	
					QC 5 - 68	
					QC 5 - 9	
					QC 5 - 50	
					QC 5 - 30	
					QC 5 - 40	
					QC 5 - 61	
					QC 5 - 81	
285 Handfinish - 3-1- WingWalk- B4B	1 pcs	10/29/19	0.00 1.56	Handfinish - 3 - 1 - B4B	M 14-9-4	
				Handfinish - 3 - 2 - B4B		
				Handfinish - 3 - 3 - B4B		
				Handfinish - 3 - 4 - B4B		
				Handfinish - 3 - 5 - B4B		
286 QC 5	1 pcs	10/29/19	0.00 0.00	QC 5 - 10		
				QC 5 - 12		
				QC 5 - 17		
				QC 5 - 18		
				QC 5 - 19		
				QC 5 - 22		
				QC 5 - 24		
				QC 5 - 3		
				QC 5 - 43		
				QC 5 - 49		
				QC 5 - 51		
				QC 5 - 58		
				QC 5 - 68		
				QC 5 - 9		
				QC 5 - 50		
				QC 5 - 30		
				QC 5 - 40	SEP 04 2019	DAS 40
				QC 5 - 61		9-89
				QC 5 - 81		
295 Packaging 3-1 - Stock - B4B	1 pcs	10/29/19	0.00 0.00	Packaging 3 - 1 - B4B		
				Packaging 3 - 2 - B4B		
				Packaging 3 - 3 - B4B		
				Packaging 3 - 4 - B4B		
				Packaging 3 - 5 - B4B		
				Packaging 3 - 6 - B4B		DAS
				Packaging 3 - 7 - B4B		19
				Packaging 3 - 8 - B4B		9-89
				Packaging 3 - 9 - B4B		
				Packaging 3 - 10 - B4B		
				Packaging 3 - 11 - B4B		
				Packaging 3 - 12 - B4B		
				Packaging 3 - 13 - B4B		
				Packaging 3 - 14 - B4B		

				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
297 DC - 1 - B4B	1	10/29/19	0.00 0.00	DC - 1 - B4B	DAS
	pcs			DC - 2 - B4B	21
300 QC 21 - FG	1	10/29/19	0.00 0.00	QC 21 - FG - 21	9-09 SEP 04 2019
	pcs			QC 21 - FG - 70	
				QC 21 - SA - 53	DAS SEP 04 2019

Part Op 110 - (Skid tubes) 1- Bend FWD end of tube using Bender 1 and bend prog D3905 FWD per dwg D3905 (FOLIO -04) 2- Descriptions: Cut FWD end of tube as per dwg D3905. 3- Cut AFT end of tube as per dwg D3905. 4- Buff out marks left from bending 5- Install drill Jig DT9480 drill X-bolt spacer pilot holes using 3/16" drill first side only. 6- 2nd side, locating from first saddle holes use DT9861 A/B to drill 2nd side fwd saddle holes. 7- 2nd side locating from fwd saddle drill remaining crossbolt spacer holes using DT9480 8- Drill FWD cap holes using DT8215.

120 - (Chemical Conversion Coat per QSI005 4.1)
130 - (QC7-Inspect Chemical Conversion Coat)
140 - (QC5- Inspect part completeness to step on W/O)
170 - (Skid tubes) Open FWD Saddle holes to finish size as per dwg and deburr 1-Bond web in place as per Dwg D3905 & QSI 015. (at 42.95" ref.) A/R Sikaflex-291 S20625 Sikaflex expire date: 20-07-25 Start: 3:30 AM Time: 3:30 AM Finish: 3:30 AM Time: 3:30 AM *** (Adhere for 12 hours)***** 2-Bend AFT end of tube using CNC Bender 1 and bend prog. D3905 AFT as per dwg D3905. Install drop pins in crossbolt spacer holes to maintain web position. 3- Drill 1.87" and 3.74 holes using DT10045 A&B locate from FWD saddle hole. (verify measurement) as per dwg. 4- Drill Tow ring hole using DT10047. Open to finished size. 5- Open FWD & AFT cap holes per dwg. Countersink Fwd cap only as per detail "C" 6-Open crossbolt spacer holes to finished size. Drill most Fwd wearplate holes using DT9816 (15.21") 7-Deburr crossbolt spacer holes as per Dwg D3905 and blow out chips from inside the tube 8- Drill holes for wearpads using DT9613 & D**
180 - (QC5- Inspect part completeness to step on W/O)
190 - (Skid tubes) NOTE:TACK IN 2 MOST FWD X-BOLT SPACERS AND TEST FIT FWD GROUND HANDLING FIXTURE,IF FIXTURE FITS WELL THEN PROCEED. FIXTURE DT10091. 1-Insert crossbolt spacers. Weld as per QSI 004 and Dwg D3905. Remember to back drill each hole before welding the other side. Use aluminum rod A/R Aluminum Rod 159011 2-Grind cross bolt welds flush as per Dwg D3905. Ensure no pin hole. 3-Counterbore 5/16" x 0.750" deep as per Dwg D3905. 4- Deburr & Scribe batch # on Aft end of tube. 5- Pick D2855-5 cap and transfer drill missing hole. Deburr and identify cap with skidtube batch#.
200 - (QC5- Inspect part completeness to step on W/O) TEST FIT USING FIXTURE DT10091.
210 - (QC10- Inspect visual per QSI004- ground welds)
220 - (Pressure Wash per QSI005 4.3/ Clean and remove all markings) Re-alodine tube as per QSI 005 section 4.1.2.1 do not acid etch.
230 - (Spray Paint / NDT Room) ***AS PER DETAIL"F" NOTE 8, SHEET 8 MASK THIS AREA, DO NOT APPLY PRIMER OR PAINT***** PRIME AS PER DWG AND QSI 005 4.2 BATCH: S206299 PAINT WHITE AS PER DWG AND QSI 005 4.2 BATCH: S204428**
240 - QC14- Inspect Spray Paint)
250 - (Assemble as per dwg) 1-Install inserts as per Dwg D3905.
260 - (QC5- Inspect part completeness to step on W/O)
270 - (Assemble as per dwg) 1-Install wearpads, gaskets and wearplates as per Dwg D3905. Put sikaflex in insert before installing bolts and washers A/R Sikaflex-240/-291 S20625 Sikaflex expire date: 20-07-25 2-assemble o'ring to plug as per dwg D3492 and apply o'ring lube A/R 55-o'ring lube batch: 3 -Inspect for foreign objects as per QSI 024 4 -Install D2855-3 Cap and seal with Sikaflex. Clean excess adhesive. A/R Sikaflex-240/-291

5174342 Sikaflex expire date: 14-12-9 5- Install insert in D2855- Cap. Install cap and seal with Sikaflex.
 Clean excess adhesive. A/R Sikaflex-240/-291 5174342 Sikaflex expire date: 14-12-9 6- Install (2) D5101-041 and (1) D5101-047 as per dwg by using DT10117
 280 - (QC5- Inspect part completeness to step on W/O)
 285 - HandFinish3 (Wing Walk as per dwg QSI005 4.4 Batch 5182147)
 286 - (QC5- Inspect part completeness to step on W/O)
 295 - (Identify as per dwg & Stock Location: _____) Identify and pack for shipping as per PPP D119-646-
 Location: _____ PPP Rev: _____
 297 - (Document Control) Photocopy bluefile & type labels per PPP D119-646-043 CHG 006
 300 - (QC21- Final Inspection - Work Order Release)

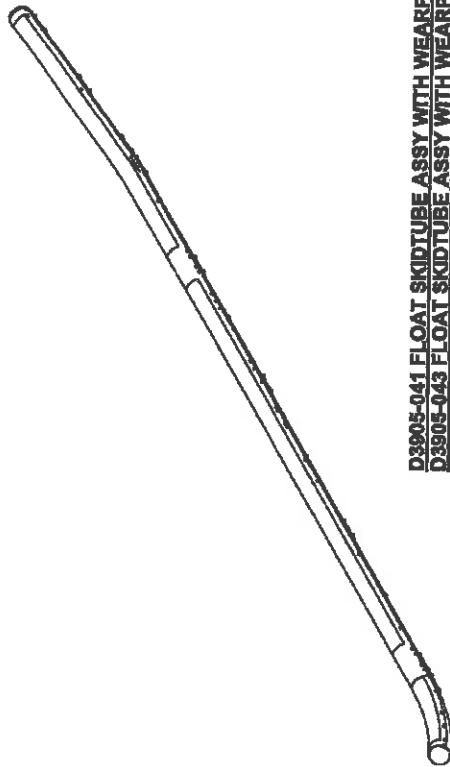
Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D2500-1-190	Ext'n -I' Beam Tube 4"	1 pcs (1 ea)	110-Skidtubes - 1	<u>5168371</u>
D3885-3	Float Web	1 pcs (1 ea)	170-Skidtubes - 2 - B4B	<u>5096476</u>
D2579	Crossbolt Spacer	2 pcs (2 ea)	190-Skidtubes - 3 - B4B	<u>5097840</u>
D2855-5	Cap	1 pcs (1 ea)	190-Skidtubes - 3 - B4B	<u>5083038</u>
D3681-1	Spacer	12 pcs (12 ea)	190-Skidtubes - 3 - B4B	<u>5188347</u>
D3903-1	Spacer	12 pcs (12 ea)	190-Skidtubes - 3 - B4B	<u>5184452</u>
ALS4-1032-130	Rivnut	42 Ea (42 ea)	250-Handfinish - 4-1-Assembly-B4B	<u>5057257</u>
D3683-3	Insert	12 pcs (12 ea)	250-Handfinish - 4-1-Assembly-B4B	<u>5174309</u>
ALS4-1032-225	Rivnut	1 Ea (1 ea)	270-Handfinish - 4-2-Assembly-B4B	<u>5209361</u>
AN3C4A	Bolt	6 Ea (6 ea)	270-Handfinish - 4-2-Assembly-B4B	<u>5207574</u>
AN3C5A	Bolt	38 Ea (38 ea)	270-Handfinish - 4-2-Assembly-B4B	<u>5266968</u>
AN4C46A	Bolt	3 Ea (3 ea)	270-Handfinish - 4-2-Assembly-B4B	<u>5126402</u>
D2855-3	Cap	1 pcs (1 ea)	270-Handfinish - 4-2-Assembly-B4B	<u>5183338</u>
D3492-5	Plug	24 pcs (24 ea)	270-Handfinish - 4-2-Assembly-B4B	<u>F164008</u>
D3672-1	Washer, Phenolic	2 pcs (2 ea)	270-Handfinish - 4-2-Assembly-B4B	
D3847-1	Wearpad	8 pcs (8 ea)	270-Handfinish - 4-2-Assembly-B4B	<u>5136646</u>
D3847-11	Wearpad	1 pcs (1 ea)	270-Handfinish - 4-2-Assembly-B4B	<u>5210627</u>
D5101-041	Crossbolt Spacer Assembly	2 pcs (2 ea)	270-Handfinish - 4-2-Assembly-B4B	<u>5145328</u>
D5101-047	Crossbolt Spacer Assembly	1 pcs (1 ea)	270-Handfinish - 4-2-Assembly-B4B	<u>5208513</u>
D5101-3	Insert	6 pcs (6 ea)	270-Handfinish - 4-2-Assembly-B4B	<u>5194901</u>
D5101-5	Insert <u>514397441</u>	6 pcs (6 ea)	270-Handfinish - 4-2-Assembly-B4B	<u>5198135</u>
MS21043-4	Nut	3 Ea (3 ea)	270-Handfinish - 4-2-Assembly-B4B	<u>5064269</u>
MS24694-C52	Screw	2 Ea (2 ea)	270-Handfinish - 4-2-Assembly-B4B	
MS27039C4-08	Screw	12 Ea (12 ea)	270-Handfinish - 4-2-Assembly-B4B	
NAS1149C0332R	Washer (AN960C10L)	44 Ea (44 ea)	270-Handfinish - 4-2-Assembly-B4B	<u>5153186</u>
NAS1611-005	O-Ring	24 Ea (24 ea)	270-Handfinish - 4-2-Assembly-B4B	<u>5180137</u>
NAS1149C0416R	Washer	6 Ea (6 ea)	270-Handfinish - 4-2-Assembly-B4B	<u>5092813</u>

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Job Allocations				
Operation	Component Part	Required	Inventory	Allocated
110-Skidtubes - 1	D2500-1-190	1	65	0
170-Skidtubes - 2 - B4B	D3885-3	1	15	0
190-Skidtubes - 3 - B4B	D2579	2	89	0
	D2855-5	1	41	0
	D3681-1	12	84	0
	D3903-1	12	79	0
250-Handfinish - 4-1-Assembly-B4B	ALS4-1032-130	42	6,816	0
	D3683-3	12	218	0
270-Handfinish - 4-2-Assembly-B4B	ALS4-1032-225	1	1,206	0
	AN3C4A	6	1,130	0
	AN3C5A	38	930	0
	AN4C46A	3	74	0
	D2855-3	1	78	0
	D3492-5	24	292	0
	D3672-1	2	1,493	0
	D3847-1	8	21	0
	D3847-11	1	8	0
	D5101-041	2	2	0
	D5101-047	1	6	0
	D5101-3	6	24	0
	D5101-5	6	36	0
	MS21043-4	3	850	0
	MS24694-C52	2	60	0
	MS27039C4-08	12	212	0
	NAS1149C0332R	44	3,043	0
	NAS1149C0416R	6	100	0
	NAS1611-005	24	454	0
Part Specifications				
Specifications could not be found.				

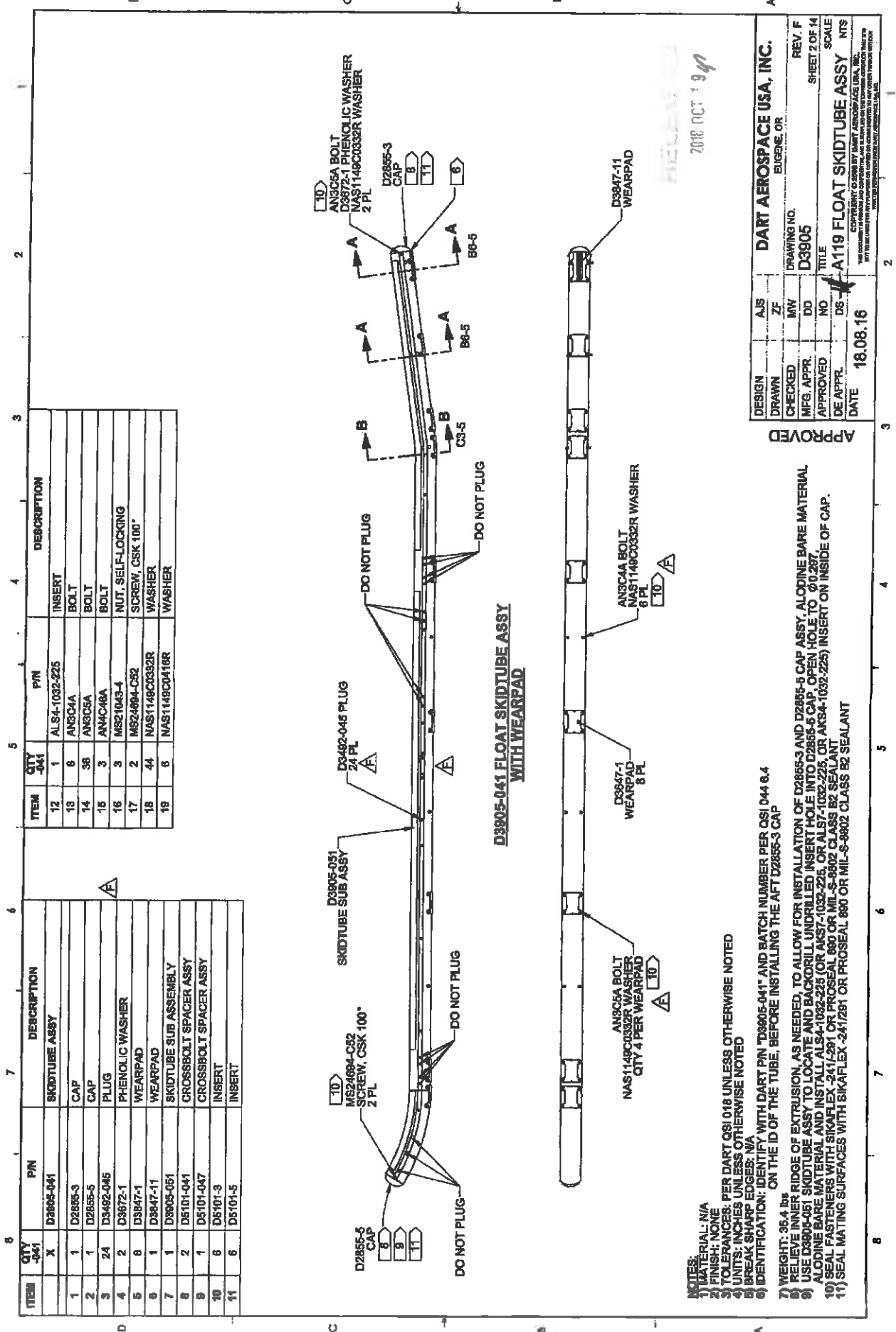
Plex 8/13/19 1:02 PM Dart.Renwick.Jennifer



D3905-041 FLOAT SKIDTUBE ASSY WITH WEARPAD (SHOWN)
D3905-043 FLOAT SKIDTUBE ASSY WITH WEARPLATE (SIMILAR)
D3905-045 FLOAT SKIDTUBE ASSY WITH TRAINING WEARPLATE (SIMILAR)

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 199136

REV.	DESIGN	AJS	DATE	DESCRIPTION	BY	DATE
1	DRAWN	ZF		DART AEROSPACE USA, INC.		
2	CHECKED	MW		EUGENE, OR		
3	MFG. APPR.	DD		D3905		
4	APPROVED	NO		TITLE		
5	DE APPR.	DS		A119 FLOAT SKIDTUBE ASSY		
6	DATE	18.08.16		SCALE		
7				SHEET 1 OF 14		
8				REV. F		
9				REV. F		
10				REV. F		
11				REV. F		
12				REV. F		
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95				REV. F		
96				REV. F		
97				REV. F		
98				REV. F		
99				REV. F		
100				REV. F		



ITEM	QTY	P/N	DESCRIPTION
12	1	ALS4-1032-225	INSERT
13	8	AN3C4A	BOLT
14	38	AN3C5A	BOLT
15	3	AN4C4A	BOLT
16	3	MS21043-4	NUT, SELF-LOCKING
17	2	MS24694-C82	SCREW, CSK 100°
18	44	NAS1149C0332R	WASHER
19	6	NAS1149C0416R	WASHER

ITEM	QTY	P/N	DESCRIPTION
1	1	D3905-041	SKIDTUBE ASSY
2	1	D2855-3	CAP
3	24	D3492-045	PLUG
4	2	D3872-1	PHENOLIC WASHER
5	8	D3847-1	WEARPAD
6	1	D3847-11	WEARPAD
7	1	D3905-051	SKIDTUBE SUB ASSEMBLY
8	2	D5101-041	CROSSBOLT SPACER ASSY
9	1	D5101-047	CROSSBOLT SPACER ASSY
10	8	D5101-3	INSERT
11	6	D5101-5	INSERT

DESIGN	ALIS	DATE	REV. F
DRAWN	ZF	18.08.16	SHEET 2 OF 14
CHECKED	MW		SCALE
MFG. APPR.	DD		NTS
APPROVED	NO		
DE APPR.	DS		

DART AEROSPACE USA, INC.
EUGENE, OR

A119 FLOAT SKIDTUBE ASSY

COMPONENT 0.2008 BY DART AEROSPACE USA, INC.
ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
TOLERANCES: PER DART Q91018 UNLESS OTHERWISE NOTED
FINISH: NONE
UNITS: INCHES UNLESS OTHERWISE NOTED
BREAK SHARP EDGES: N/A
IDENTIFICATION: IDENTIFY WITH DART PIN "D3905-041" AND BATCH NUMBER PER Q91044 8.4
ON THE ID OF THE TUBE, BEFORE INSTALLING THE AFT D2855-3 CAP

WEIGHT: 35.4 lbs

RELIEVE INNER RIDGE OF EXTRUSION, AS NEEDED, TO ALLOW FOR INSTALLATION OF D2855-3 AND D2855-5 CAP ASSY. ALDINE BARE MATERIAL

USE D3905-051 SKIDTUBE ASSY TO LOCATE AND BACKDRILL UNDRILLED INSERT HOLE INTO D2855-5 CAP. OPEN HOLE TO Ø0.2571

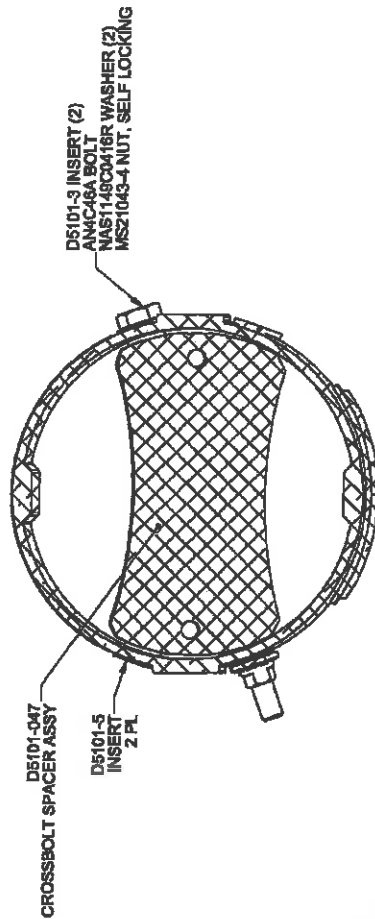
ALDINE BARE MATERIAL AND INSTALL ALS4-1032-225 OR AKS7-1032-225 OR AKS4-1032-225 INSERT ON INSIDE OF CAP.

10) SEAL FASTENERS WITH SIKAFLEX -241/291 OR PROSEAL 880 OR MIL-S-8902 CLASS B2 SEALANT

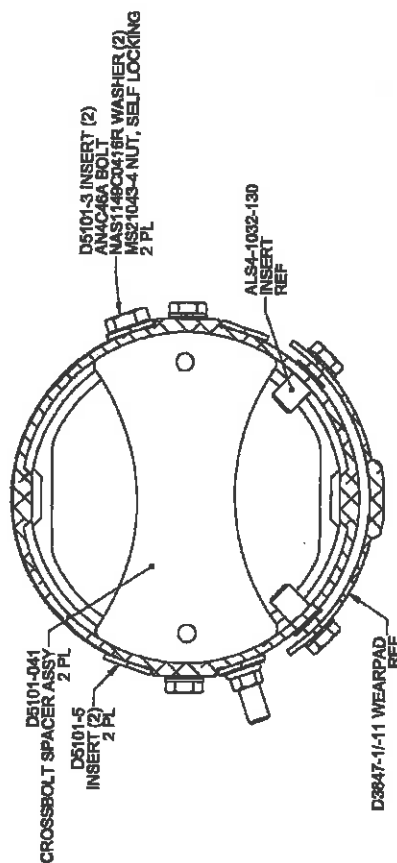
11) SEAL MATING SURFACES WITH SIKAFLEX -241/291 OR PROSEAL 880 OR MIL-S-8902 CLASS B2 SEALANT

1 2 3 4 5 6 7 8

D C B A



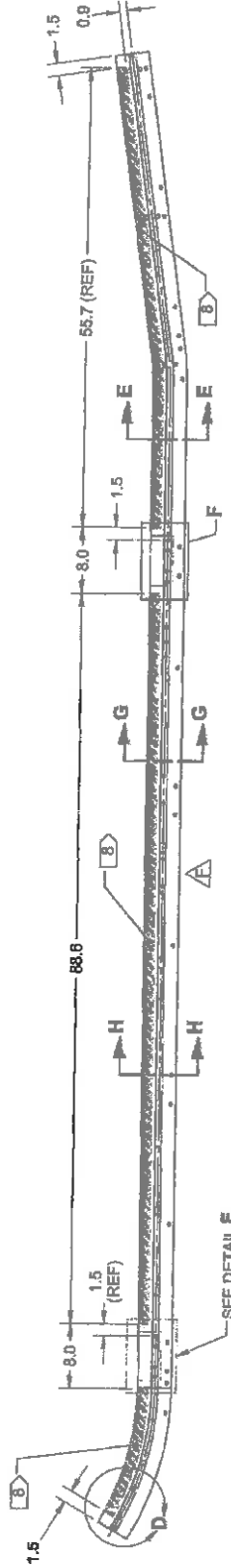
SECTION B-B
SCALE 12X



SECTION A-A
SCALE 12X

DESIGN	AJS	DART AEROSPACE USA, INC.
DRAWN	ZF	EUGENE, OR
CHECKED	MW	
INFO. APPR.	DD	
APPROVED	NO	
DE APPR.	DS	
DATE	18.08.16	
APPROVED		
DRAWING NO. D3905		
REV. F		
SHEET 3 OF 14		
TITLE A119 FLOAT SKIDTUBE ASSY		
SCALE NTS		
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ITEM	QTY	P/N	DESCRIPTION
1	X	D3905-051	SKIDTUBE SUB ASSY
2	2	D2579	CROSS BOLT SPACER
3	12	D3905-1	SPACER
4	12	D3905-1	SPACER
5	1	D3905-081	SKIDTUBE SUB ASSEMBLY
6	42	ALS4-1032-130	INSERT



D3905-051 SKIDTUBE SUB ASSEMBLY

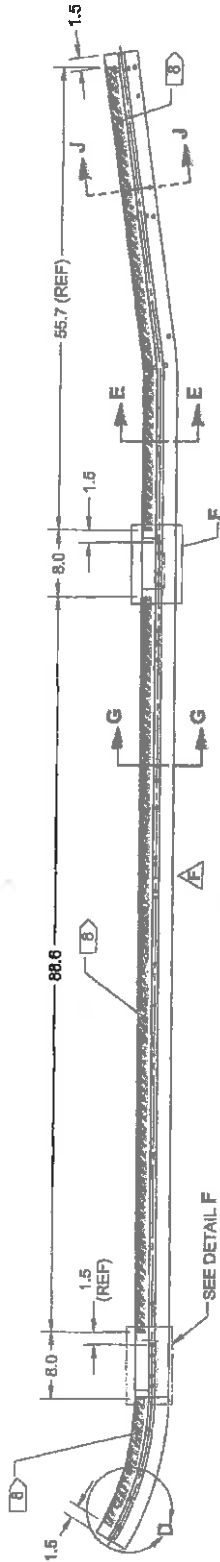
- NOTES:
- 1) MATERIAL: N/A
 - 2) FINISH: PRIME (REF 4.2.1.3.3) AND PAINT WHITE PER DART QSI 005 4.2.2.4
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: N/A
 - 6) IDENTIFICATION: IDENTIFY AT NEXT ASSEMBLY
 - 7) WEIGHT: N/A
 - 8) AS INDICATED TO 0.30" ABOVE LOCATION RIDGE, PER QSI 005 SECTION 4.4

DESIGN	AJS	DART AEROSPACE USA, INC.	
DRAWN	ZF	EUGENE, OR	
CHECKED	MW	DRAWING NO.	D3905
MFG. APPR.	DO	TITLE	A119 FLOAT SKIDTUBE ASSY
APPROVED	NO	SCALE	NTS
DE APPR.	DS	SHEET 6 OF 14	
DATE	18.08.16		

APPROVED

RELEASED 9/97

ITEM	QTY	P/N	DESCRIPTION
1	X	D3905-053	SKIDTUBE SUB ASSY
2	2	D2579	CROSS BOLT SPACER
3	12	D3903-1	SPACER
4	1	D3905-053	SKIDTUBE SUB ASSEMBLY
5	10	ALS4-1032-130	INSERT

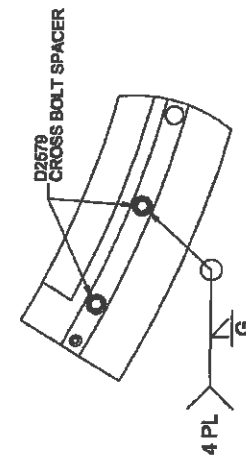


D3905-053 SKIDTUBE SUB ASSEMBLY

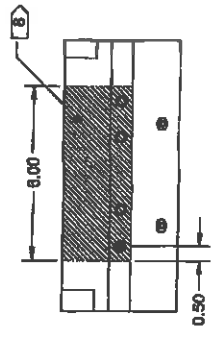
- NOTES:
- 1) MATERIAL: N/A
 - 2) FINISH: PRIME (REF 4.2.1.3.3) AND PAINT WHITE PER DART QSI 005 4.2.2.4
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: N/A
 - 6) IDENTIFICATION: IDENTIFY AT NEXT ASSEMBLY
 - 7) WEIGHT: N/A
 - 8) AFTER APPLICATION OF FINISH, PAINT TOP SURFACE OF SKIDTUBE WITH MIL-W-5044 ANTI-SKID PAINT (WING WALK) AS INDICATED TO 0.50" ABOVE LOCATION RIDGE, PER QSI 005 SECTION 4.4

DESIGN	ALIS	DATE	18.08.16
DRAWN	ZF		
CHECKED	MW		
MFG. APPR.	DD		
DE APPR.	NO		
	DS		
DRAWING NO.		D3905	
REV. F		SHEET 7 OF 14	
TITLE		A119 FLOAT SKIDTUBE ASSY	
SCALE		NTS	
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EUGENE, OR			
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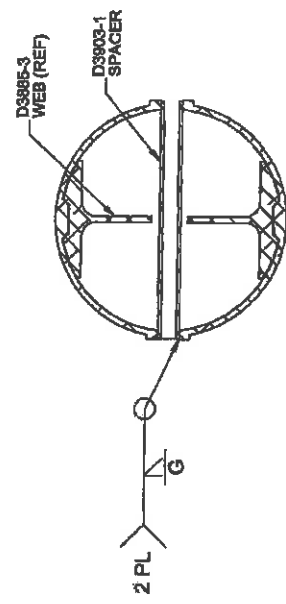
RELEASED
21-1940



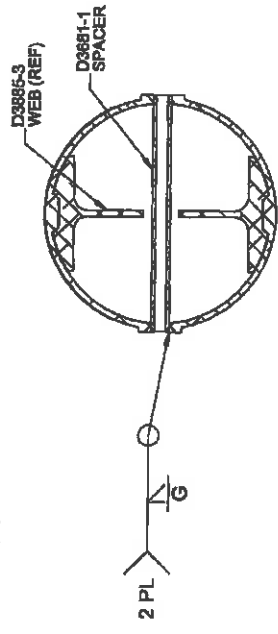
DETAIL D
SCALE: 3.5X



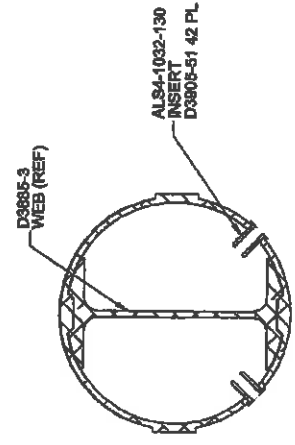
DETAIL F
SCALE: 3.5X



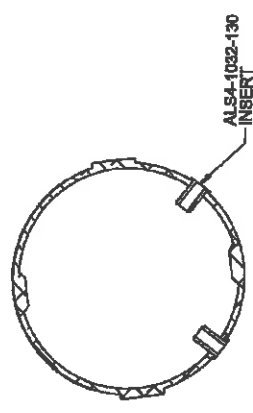
SECTION G-G
SCALE: 7X
12 PL



SECTION E-E
SCALE: 7X
12 PL



SECTION H-H
SCALE: 7X
12 PL

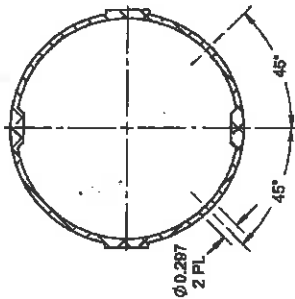
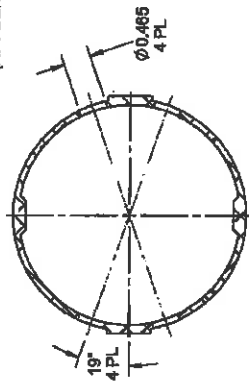
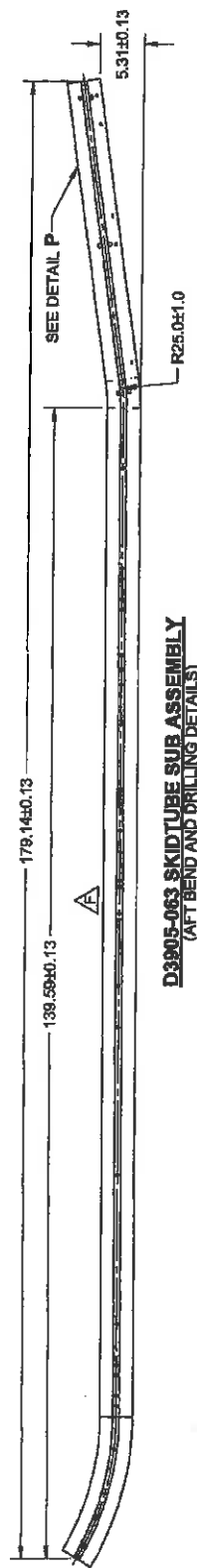
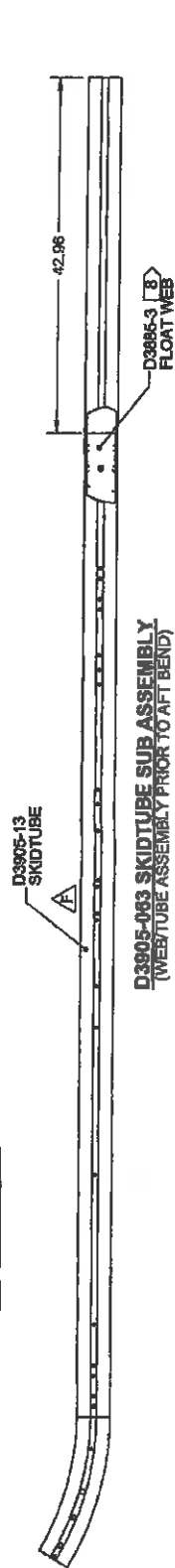


SECTION J-J
SCALE: 7X
12 PL

- NOTES:**
- 1) MATERIAL: N/A
 - 2) FINISH: PRIME (REF 4.2.1.3.3) AND PAINT WHITE PER DART QSI 005 4.2.2.4
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: IDENTIFY AT FINAL ASSEMBLY
 - 7) WEIGHT: N/A
 - 8) MASK THIS AREA AND DO NOT APPLY PRIMER OR PAINT
 - 9) AFTER DRILLING AND BENDING ASSEMBLY, PERFORM THE FOLLOWING FOR THE SECTION G-G Ø0.313 HOLES ONLY:
 - i) CHAMFER HOLES Ø0.475 x 45°
 - ii) INSERT D3803-1 SPACER
 - iii) WELD INTO PLACE AND GRIND FLUSH
 - iv) BORE TO Ø0.313 x 0.75 DEEP
 - v) DEBURR HOLES
 - 10) AFTER DRILLING AND BENDING ASSEMBLY, PERFORM THE FOLLOWING FOR THE SECTION E-E Ø0.313 HOLES ONLY:
 - i) CHAMFER HOLES Ø0.354 x 45° OR 0.050 DEEP x 45° (BOTH SIDES)
 - ii) INSERT D3881-1 SPACER
 - iii) WELD INTO PLACE AND GRIND FLUSH
 - iv) DEBURR HOLES
 - 11) WELD PER DART QSI 004

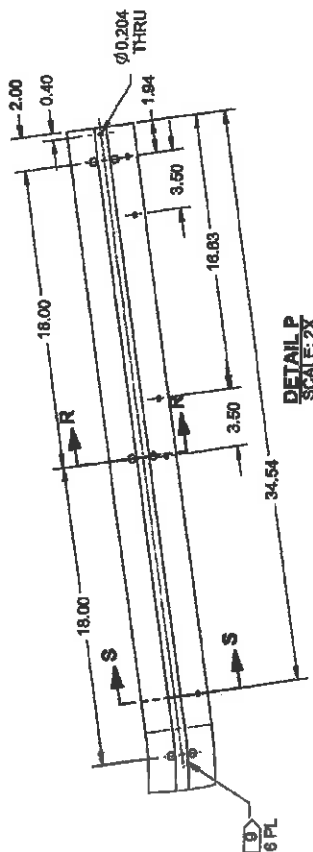
DESIGN	AJS	DESIGN NO.	REV. F
DRAWN	ZF	D3905	SHEET 5 OF 14
CHECKED	MW		
MFG. APPR.	DO		
APPROVED	NO		
DATE	18.08.16		
DART AEROSPACE USA, INC.			
EUGENE, OR			
TITLE			
A119 FLOAT SKIDTUBE ASSY			
SCALE			
N/A			

ITEM	QTY	P/N	DESCRIPTION
			SKIDTUBE SUB ASSEMBLY
1	1	D3905-063	SKIDTUBE SUB ASSEMBLY
2	1	D3885-3	SKIDTUBE SUB ASSEMBLY
3	1	D3885-3	SKIDTUBE SUB ASSEMBLY
4	1	D3885-3	SKIDTUBE SUB ASSEMBLY
5	1	D3885-3	SKIDTUBE SUB ASSEMBLY
6	1	D3885-3	SKIDTUBE SUB ASSEMBLY
7	1	D3885-3	SKIDTUBE SUB ASSEMBLY
8	1	D3885-3	SKIDTUBE SUB ASSEMBLY



SECTION R-R
3 PL
SCALE: 7X

SECTION S-S
5 PL
SCALE: 7X



- NOTES:
- 1) MATERIAL: N/A
 - 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: IDENTIFY AT FINAL ASSEMBLY
 - 7) WEIGHT: N/A
 - 8) INSERT D3885-3 WEB TO LOCATION SHOWN OFF AFT END OF SKIDTUBE AND BOND WEB INTO OUTER TUBE WITH SIKAFLEX-241-291 ADHESIVE PER DART QSI 015 AFTER BENDING. ENSURE HOLES LINE-UP
 - 9) RELIEVE RIDGE FLUSH WITH SKIDTUBE FOR INSERT CLEARANCE, MAX 0.130 INTO RIDGE

DESIGN	AJS	DART AEROSPACE USA, INC.	REV. F
DRAWN	ZF	EUGENE, OR	
CHECKED	MM	DRAWING NO.	D3905
MFG. APPR.	DD	TITLE	A119 FLOAT SKIDTUBE ASSY
DE APPR.	DD	SCALE	10 OF 14
DATE	18.08.16		

APPROVED

DATE 18.08.16

SCALE 10 OF 14

TITLE A119 FLOAT SKIDTUBE ASSY

DRAWING NO. D3905

DESIGNER AJS

CHECKED MM

DART AEROSPACE USA, INC.

EUGENE, OR

REV. F

10 OF 14

SCALE

A119 FLOAT SKIDTUBE ASSY

D3905

DRAWING NO.

EUGENE, OR

DART AEROSPACE USA, INC.

REV. F

10 OF 14

SCALE

A119 FLOAT SKIDTUBE ASSY

D3905

DRAWING NO.

EUGENE, OR

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D3905

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REV. F

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A119 FLOAT SKIDTUBE ASSY

D3905

DRAWING NO.

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D3905

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EUGENE, OR

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A119 FLOAT SKIDTUBE ASSY

D3905

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EUGENE, OR

DART AEROSPACE USA, INC.

REV. F

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SCALE

A119 FLOAT SKIDTUBE ASSY

D3905

DRAWING NO.

EUGENE, OR

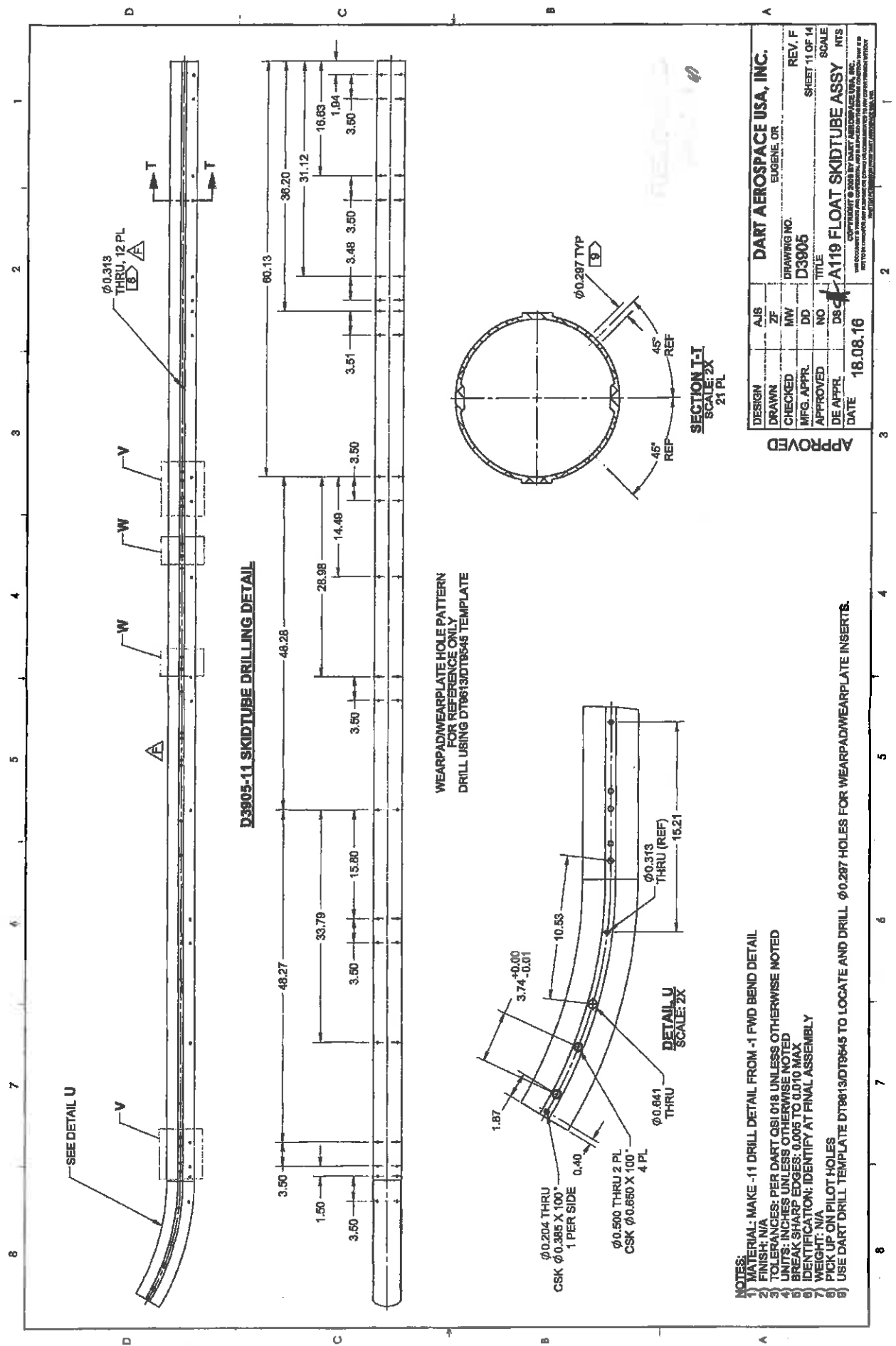
DART AEROSPACE USA, INC.

REV. F

10 OF 14

SCALE

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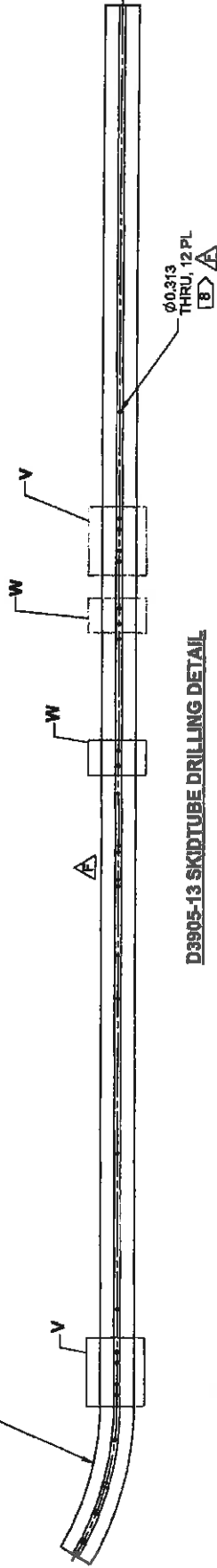
DESIGN	AJS	DART AEROSPACE USA, INC.
DRAWN	ZF	EUGENE, OR
CHECKED	MW	DRAWING NO. D3905
MFG. APPR.	DD	REV. F
APPROVED	NO	SHEET 11 OF 14
DATE	18.08.16	SCALE NTS
TITLE: A119 FLOAT SKIDTUBE ASSY		

APPROVED

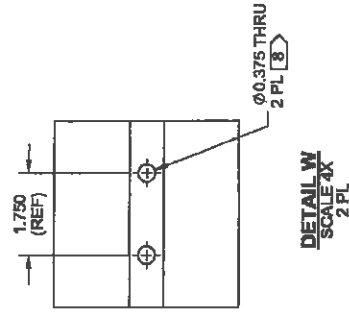
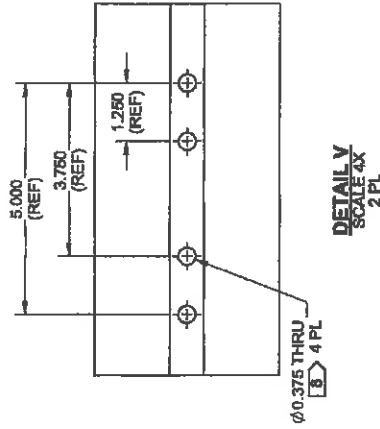
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8 7 6 5 4 3 2

SEE DETAIL U



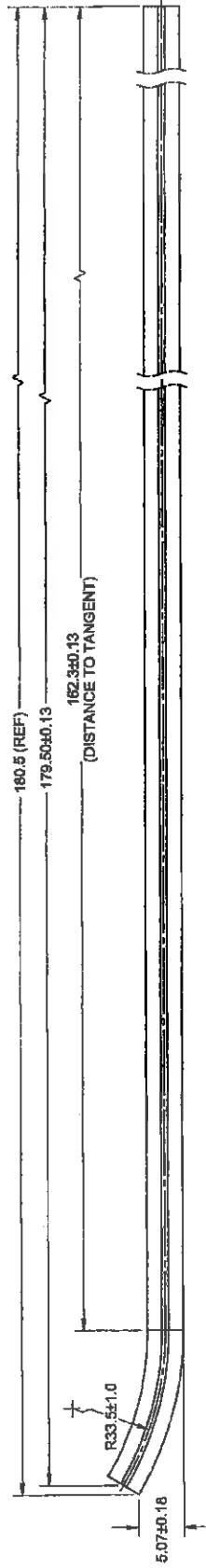
D3905-13 SKIDTUBE DRILLING DETAIL



- NOTES:
- 1) MATERIAL: MAKE -13 DRILL DETAIL FROM -1 FWD BEND DETAIL
 - 2) FINISH: N/A
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: IDENTIFY AT FINAL ASSEMBLY
 - 7) WEIGHT: N/A
 - 8) PICK UP ON PILOT HOLES

DESIGN	AJS	DART AEROSPACE USA, INC.
DRAWN	ZF	EUGENE, OR
CHECKED	MW	DRAWING NO. D3905
MFG. APPR.	DD	REV. F
APPROVED	NO	SHEET 12 OF 14
DE APPR.	DE	TITLE A119 FLOAT SKIDTUBE ASSY
DATE	18.08.16	SCALE NTS

COMPONENT OF DART AEROSPACE USA, INC.
18.08.2016 10:00:00 AM
18.08.2016 10:00:00 AM
18.08.2016 10:00:00 AM



D3905-1 SKIDTUBE FWD BEND DETAIL

- NOTES:
- 1) MATERIAL: MAKE -1 FWD BEND DETAIL FROM .3 PILOT HOLE DETAIL
 - 2) FINISH: N/A
 - 3) TOLERANCES: PER DART QSI 0.18 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.006 TO 0.010 MAX
 - 6) IDENTIFICATION: IDENTIFY AT FINAL ASSEMBLY
 - 7) WEIGHT: N/A
 - 8) DAMAGE TOLERANCE ON FWD BEND: THERE SHOULD BE NO VISIBLE WRINKLES IN THE BEND FROM THE GROUND TO A HEIGHT OF 8.5 INCHES ABOVE THE GROUND. IT IS ACCEPTABLE TO POLISH OUT GOUGES UP TO 0.020" DEEP IN THE BENT PORTION OF THE TUBE. A MAXIMUM REDUCTION IN DIAMETER OF 0.150" IS ACCEPTABLE IN THE BENT PORTION OF THE TUBE.

APPROVED

DESIGN	DESIGNED	DATE	18.08.16
DRAWN	APPROVED	DATE	18.08.16
CHECKED	APPROVED	DATE	18.08.16
MFG. APPR.	APPROVED	DATE	18.08.16
DE APPR.	APPROVED	DATE	18.08.16
DRAWING NO.		D3905	
TITLE		A119 FLOAT SKIDTUBE ASSY	
REV. F		SHEET 13 OF 14	
SCALE		N/A	
PART NO.		A119	
REV. F		SHEET 13 OF 14	
SCALE		N/A	
PART NO.		A119	

DART AEROSPACE USA, INC.
EUGENE, OR

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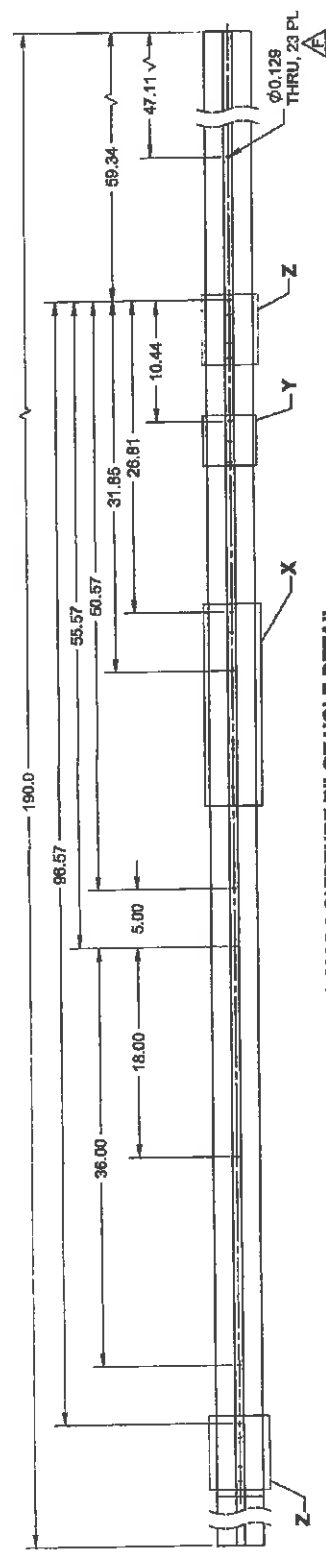
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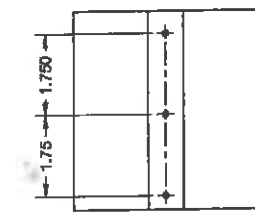
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B

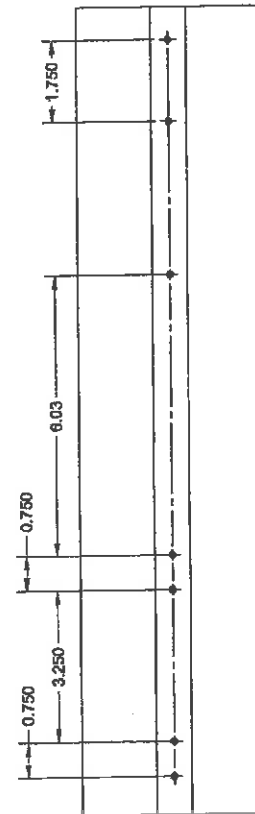
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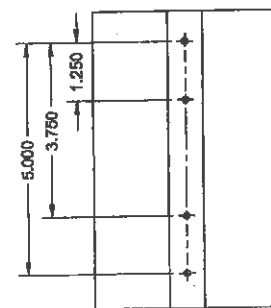
D3905-3 SKIDTUBE PILOT HOLE DETAIL



DETAIL Y
SCALE: 4X



DETAIL X
SCALE: 4X



DETAIL Z
SCALE: 4X

DART AEROSPACE USA, INC.
EUGENE, OR

DESIGN	AJS	REV. F
DRAWN	ZF	DRAWING NO.
CHECKED	MW	D3905
MFG. APPR.	DD	SHEET 14 OF 14
APPROVED	NO	TITLE
DE APPR.	DS	A1118 FLOAT SKIDTUBE ASSY
DATE	18.08.16	SCALE
		NTS

APPROVED

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- NOTES:
- 1) MATERIAL: MAKE FROM D2500-1-190 EXTRUSION
 - 2) FINISH: N/A
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: IDENTIFY AT FINAL ASSEMBLY
 - 7) WEIGHT: N/A

COMPONENT IS MADE BY DART AEROSPACE USA, INC.
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